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RBW6505G00231-3T
Job Sheet 184759



Part No: RBW6505G00231-3T

Job Qty: 1 ea

Part Name: AW139 Tail Rotor Gear Box Seal Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 11/20/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBW6505G00231-3T Rev 3 IPP Rev A 18.02.07 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/20/18	11/20/18	0.00	0.00	Start Up Small Fab-4		MCC
110	Small Fab	1 pcs	11/20/18	11/20/18	0.00	1.00	Small Fab-4		MCC DAS
120	QC	1 pcs	11/20/18	11/20/18	0.00	0.00	QC4		OCT 26 2018 68
130	Packaging	1 pcs	11/20/18	11/20/18	0.00	0.00	Packaging3-1		DAS 9-89
140	QC21-FG	1 Ea	11/20/18	11/20/18	0.00	0.00	QC21		21 OCT 26 2018 9-89

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-IM2700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6505G00231-3T-15 to RBW6505G00231-3T-13 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	
APP-IM2700-E	Case	1 Ea (1 ea)	110-Small Fab	5089128
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5119566
RBW6500X01611-W142H-3T	Tail Rotor Gear Box Output Oil Seal Removal & Press Tool	1 Ea (1 ea)	110-Small Fab	502040
RBW6505G00231-3T-11	Bottom Tool Cushion	1 Ea (1 ea)	110-Small Fab	5120550
RBW6505G00231-3T-13	Top Tool Cushion	1 Ea (1 ea)	110-Small Fab	5119574
RBW6505G00231-3T-15	Inside Placard	1 Ea (1 ea)	110-Small Fab	5119577
RBW6522A00231-W142AJ-3T	Tail Rotor Gear Box/Servo Actuator Oil Seal Fit/Extracting Tool	1 Ea (1 ea)	110-Small Fab	5121196
RBW6522A00231-W142AK-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Press Tool	1 Ea (1 ea)	110-Small Fab	5067367
RBW6522A00231-W142S-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support Tool	1 Ea (1 ea)	110-Small Fab	506472
				5061702



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Container No: S121203

Part: FBW6505G00231-3T

Job No: 184759

Serial No/Batch: S121203

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 10/24/18

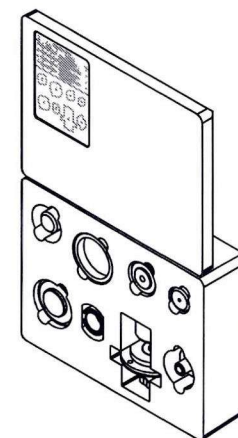
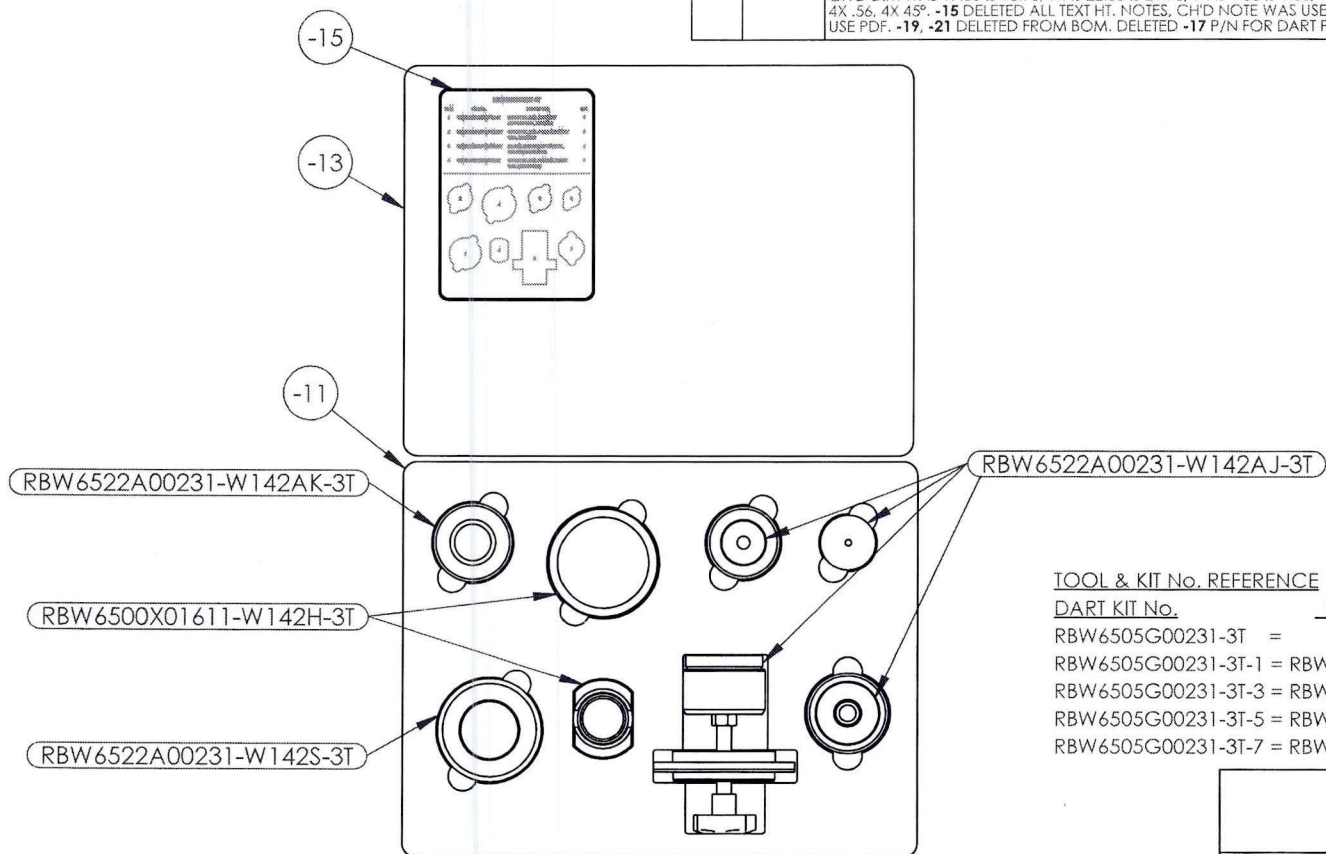
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 110-Small Fab	97524A032	4	827	0
	APP-IM2700-E	1	2	0
	RB41011	1	746	0
	RBW6500X01611-W142H-3T	1	0	0
	RBW6505G00231-3T-11	1	0	0
	RBW6505G00231-3T-13	1	0	0
	RBW6505G00231-3T-15	1	0	0
	RBW6522A00231-W142AJ-3T	1	2	0
	RBW6522A00231-W142AK-3T	1	5	0
	RBW6522A00231-W142S-3T	1	5	0
Part Specifications				
Specifications could not be found.				

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-11
-13

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-11 CH'D DEPTH WAS 3-1/2 IS 4-3/4, WAS 4-3/4 IS 5-9/16. -13 CH'D PLACARD LOCATION CUTOUT WAS HITTING TOOL WITH LID CLOSED.	10/2/2012	RJC	SE
2	15-0145	-11 ADDED MISSING DIM 8X R.13. -13 CH'D DIM WAS .07 IS .13. -15 REPLCED CONTENTS LIST WITH RBW6505G00231-3T. DELETED LINES FROM TOOL LAYOUT, ADDED ITEM NUMBERS TO TOOL LAYOUT. ADDED -19 AND -21.	6/23/2015	RJC	JAG
3	16-0254	-11, -13, -15 CH'D DWG. TO SHEET METAL TOLERANCE. -11, -13 CH'D MATERIAL AND VENDOR WAS Y20 BLACK I.R. SPECIALTY FOAM IS ETHAFOAM 220, BLACK (CASE SOLUTIONS). -11 CH'D DIM WAS 17.00 IS 17.15, WAS 22.00 IS 22.15, WAS 6.00 IS 6.08, WAS 4X 4" IS 4X 2". ADDED DIM 4X .65, 4X 45°. -13 CH'D DIM WAS 17.00 IS 16.96, WAS 22.00 IS 21.95, WAS 1.88 IS 1.83, WAS 4X 4" IS 4X 2", ADDED DIM 4X .56, 4X 45°. -15 DELETED ALL TEXT HT. NOTES, CH'D NOTE WAS USE PDF FOR MANUFACTURING IS USE PDF. -19, -21 DELETED FROM BOM. DELETED -17 P/N FOR DART PLACARD.	12/5/2016	RJC	JAG



TOOL & KIT No. REFERENCE

DART KIT No.	DART TOOL No.	ORIGINAL No.
RBW6505G00231-3T	=	3T6505G00231
RBW6505G00231-3T-1	= RBW6522G00231-W142S-3T	= 3T6522G00231-W142S
RBW6505G00231-3T-3	= RBW6522G00231-W142AK-3T	= 3T6522G00231-W142AK
RBW6505G00231-3T-5	= RBW6522G00231-W142AJ-3T	= 3T6522G00231-W142AJ
RBW6505G00231-3T-7	= RBW6500X01611-W142H-3T	= 3T6500X01611-W142H

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			1	1	TGB/MAST OUTPUT OIL SEAL ASSEMBLY SUPPORT TOOL		RBW6522A00231-W142S-3T	1
			1	1	OUTPUT OIL SEAL PRESS TOOL		RBW6522A00231-W142AK-3T	1
			1	1	TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL		RBW6522A00231-W142AJ-3T	1
			1	1	TGB OUTPUT OIL SEAL REMOVAL AND PRESS TOOL		RBW6500X01611-W142H-3T	1
		B/O	-9	1	CASE	BLACK PLASTIC	PELICAN #APP-IM2700-E	N/S
		B/O	-11	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	6.08 X 17.15 X 22.15 (CASE SOLUTIONS)	2
		B/O	-13	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	1.83 X 16.96 X 21.95 (CASE SOLUTIONS)	3
			-15	1	INSIDE PLACARD	PLASTIC		4
		B/O		1	DART PLACARD	ALUMINUM	#RB41011	N/S

DART AEROSPACE	
TITLE TGB SEAL REPLACEMENT TOOL KIT	
DWG NO. RBW6505G00231-3T	REV 3
MAT'L TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: PERRITT	USED ON MODEL AW139
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:8	DATE 1/3/2009
SHEET 1 OF 4	